

AMENDMENTS TO THE CLAIMS:

This listing of claims will replace all prior versions, and listings of claims in the application:

LISTING OF CLAIMS:

1.(original) Method for manufacturing injection-moulded plastic products, in which method an IM film is used, which travels continuously through several steps known as such, in which the IM film is processed so that a desired image, text or other such desired design can be achieved onto it, characterised in that the processed IM film is directed to the injection moulding process, in which the product and the IM film are combined, after which the combination is transferred to a platform or, for example, directly to the assembly line of mobile phones in an integrated upgrading system.

2.(original) Method according to claim 1, in which plastic products are manufactured, for example, for the following devices: mobile phones, game consoles, press buttons, keyboards, sockets, wrist watches, clocks in general, suitcases, attachea cases, document cases, trays, sports equipment, such as frisbee, skateboard, snowboard, consumer goods in general, furnishing parts for cars, furnishing parts for aeroplanes, characterised in that the different work processes have been combined as an integrated part to the injection moulding process and that all steps have been synchronised with each other.

3.(currently amended) Method according to claim 1 [[or 2]], characterised in that the steps comprise, among others, the piezo printing/laser printing method, laser engraving method, the hardening method of UV colour/paint, vacuum methods, deep drawing or some other formatting method of the IM film, injection

moulding method, vacuum metal- lisation, laser cutting, painting/lacquering with piezo sprays.

4.(currently amended) Method according to claim 1,~~2 or 3~~, characterised in that all work processes are digitally controllable.

5.(currently amended) Method according to ~~one of the preceding elaims~~ claim 1, characterised in that the design and formation of the image, surface is conducted digitally.

6.(currently amended) Method according to ~~one of the preceding elaims~~ claim 1, characterised in that the manufacture and all the work processes are directly controllable by means of the Internet.

7.(currently amended) Method according to ~~one of the preceding elaims~~ claim 1, characterised in that the IM film is clean.

8.(currently amended) Method according to ~~one of the preceding elaims~~ claim 1, characterised in that the IM film is continuous and that it simultaneously forms a conveyor.

9.(currently amended) Method according to ~~one of the preceding elaims~~ claim 1, in which the deep drawing or overpressure process is used in the 3d formatting, characterised in that the IM film is directed, aligned on mechanically moving auxiliary surfaces/planes.

10.(currently amended) Method according to ~~one of the preceding elaims~~ claim 1, characterised in that the IM film is formatted before the injection moulding step and that the vacuum processes are directed to a finished 3d formatted IM film before the injection moulding process.

11.(currently amended) Method according to ~~one of the preceding~~  
~~claims~~ claim 1, in which vacuum metallisation has been combined  
to the production process e. g. for screening, characterised in  
that the work process is performed to the inner surface of the  
workpiece after the injection moulding process.

12.(currently amended) Method according to ~~one of the preceding~~  
~~claims~~ claim 1, characterised in that the removal/detachment of  
the workpiece from the IM film, which forms the conveyor as the  
end of all work processes, is conducted by a laser work process.

13.(currently amended) Method according to ~~one of the preceding~~  
~~claims~~ claim 1, characterised in that the workpiece is detached  
from the IM film part by a laser method, and that the work- piece  
has been placed to a work plane, which is at least biaxial x, y  
or triaxial x, y,z so that the laser beam would always align  
correctly.

14.(new) Method according to claim 2, characterised in that the  
steps comprise, among others, the piezo printing/laser printing  
method, laser engraving method, the hardening method of UV  
colour/paint, vacuum methods, deep drawing or some other  
formatting method of the IM film, injection moulding method,  
vacuum metallisation, laser cutting, painting/lacquering with  
piezo sprays.